

SPLIT

Dart Aerospace Ltd.

Date: Thursday, 11/9/2006 4:36:02 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HELI-ACCESS STEP LH (FOLDING)	
Job Number	: 29384 ✓		Part Number	: D412630033	
Estimate Number	: 12567		Drawing Number	: IIN D412-630 REV K	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/9/2006 S.O. No. N/A		Drawing Revision	: K	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 11/27/2006 Qty: 4	
Previous Run	: N/A		Um:	5 Each	
Written By	: <i>KA</i> 06/11/10				
Checked & Approved By					
Comment	: Est. Rev:A New Issue 06-11-08 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-033 CHG001			
2.0	D2012107	Clevis	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Clevis Pick: Qty Part Number Description Batch 1 D2012-107 Clevis B27522 x 3 mx			
3.0	D2803041	Bracket Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch 1 D2803-041 Bracket Assembly LH B29391 x 3 mx			
4.0	D2804041	Bracket Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch 1 D2804-041 Bracket Assembly LH B27102 x 3 mx			
<i>PLM 02-01 07.02.01</i> D2808 Bushing B28600 x 6 mx			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D2807	Support Prop
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Support Prop

Pick:

Qty	Part Number	Description	Batch
2	D2807	Gas Spring	<i>B 27562 x 8 mx B 26646 x 2 mx</i>

6.0	D2813	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
2	D2813	Washer	<i>B 29396 x 6 mx</i>

7.0	D3562041	STEP ASSEMBLY, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description	Batch
1	D3562-041	Step Weldment LH	<i>B 29411 x. 3 mx</i>

8.0	D33951	Bushing
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
4	D3395-1	Bushing	<i>B 28455 x 12 mx</i>

9.0	AN3C21A	BOLT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
2	AN3C21A	Bolt	<i>m101189 x 6 mx</i>

W/O:		WORK ORDER CHANGES					
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Job Number: 29384

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
10.0	AN8C16	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
	Bolt	
	Pick:	
	Qty Part Number Description Batch	
X	2 AN8C16 Bolt	m100695 x 6 mx
11.0	AN310C8	Nut
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
	Nut	
	Pick:	
X	Qty Part Number Description Batch	
X	2 AN310C8 Nut	m100433 x 6 mx
12.0	MS24665302	Cotter Pin
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
	Cotter Pin	
	Pick:	
X	Qty Part Number Description Batch	
X	2 MS24665-302 Cotter Pin (or AN380C3-4)	m100941 x 6 mx
13.0	NAS1515H3	Washer
	Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)	
	Washer	
	Pick:	
X	Qty Part Number Description Batch	
X	6 NAS1515H3 Washer	m100993 x 18 mx
14.0	NAS1515H5L	WASHER
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)	
	WASHER	
	Pick:	
X	Qty Part Number Description Batch	
X	4 NAS1515H5L Washer	m100683 x 12 mx

W/O:		WORK ORDER CHANGES					
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Job Number: 29384		Part Number: D412630033
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
15.0	NAS1515H8 	Washer 
Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) Washer Pick: Qty Part Number Description Batch 4 NAS1515H8 Washer M102067 x12 mx		
16.0	MS210433 	Nut 
Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) Nut Pick: Qty Part Number Description Batch 4 MS21043-3 Nut M102545 x12 mx		
17.0	MS24693C280 	Screw 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Screw Pick: Qty Part Number Description Batch 2 MS24693-C280 Screw (or MS24694-C565) M101390 x6 mx		
18.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per dwg D412-630 p.14 Coat all hardware with LPS3 rust inhibitor A/R LPS3 batch: <u>m101472</u>		MF. 07-02-01 ③
COAT exposed HARDWARE WITH LPS PROCYON. A/R LPS PROCYON BATCH: <u>m17045</u>		MF. 07-02-01 ③
19.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		SB 07/02/01 ③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-1	Bushing	B27285 6X✓

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-3	Bushing	B27286 2X B28163 4X✓

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2810-5	Strut	B27103 3X✓

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3396-1	Spacer	B27290 6X✓

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C6A	Bolt	M100651 3X✓

W/O:		WORK ORDER CHANGES					
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Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C10A	Bolt	M10C273

27.0 AN4C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4C15A	Bolt	M100447

28.0 AN44C7A Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN44-C7A	Eyebolt	M101711

29.0 AN5C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN5C15A	Bolt	M100229

30.0 NAS1515H4 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H4	Washer	M101428

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/02/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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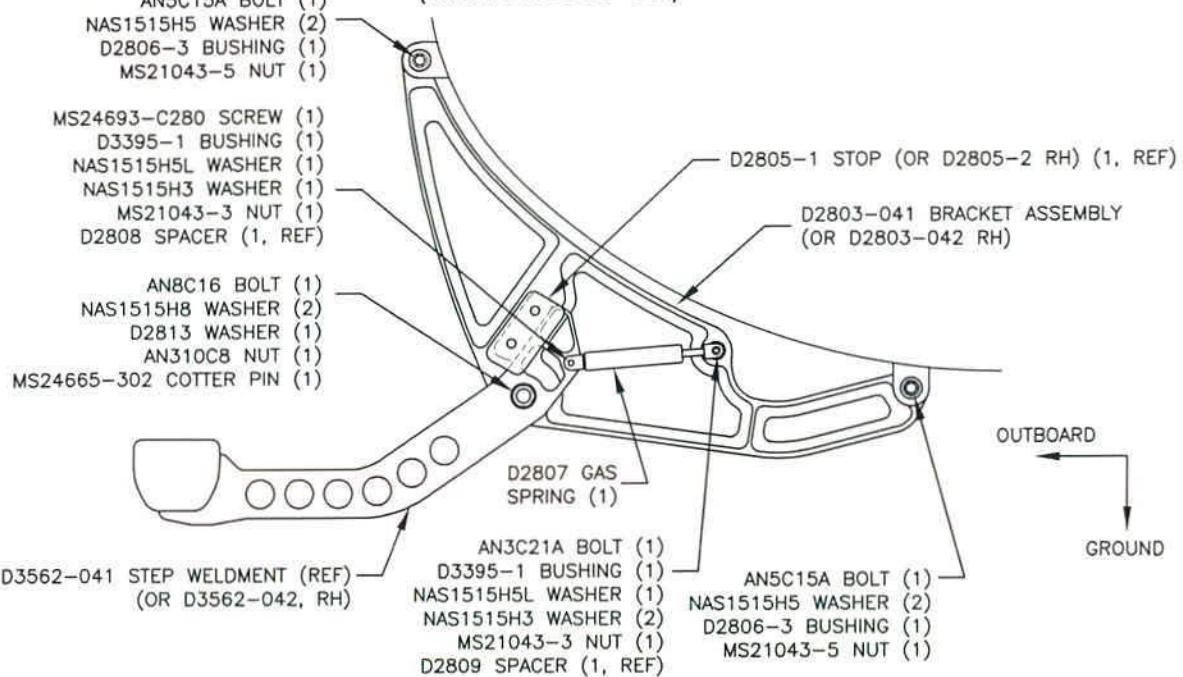
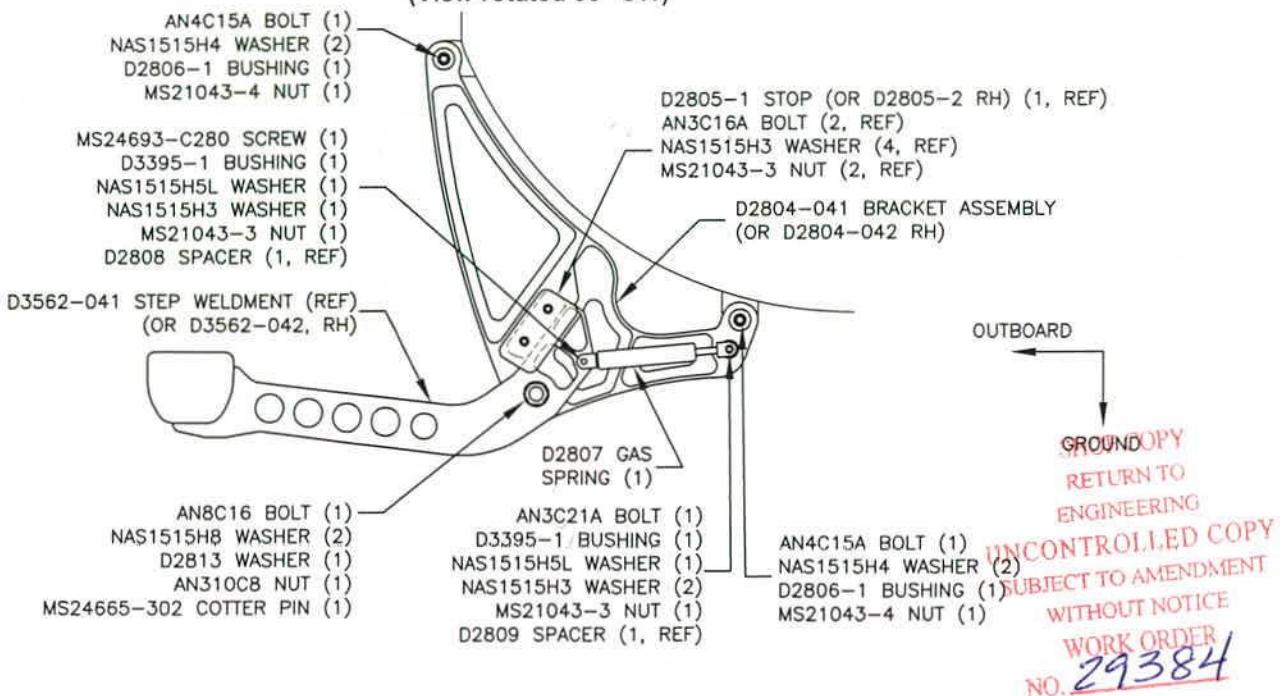
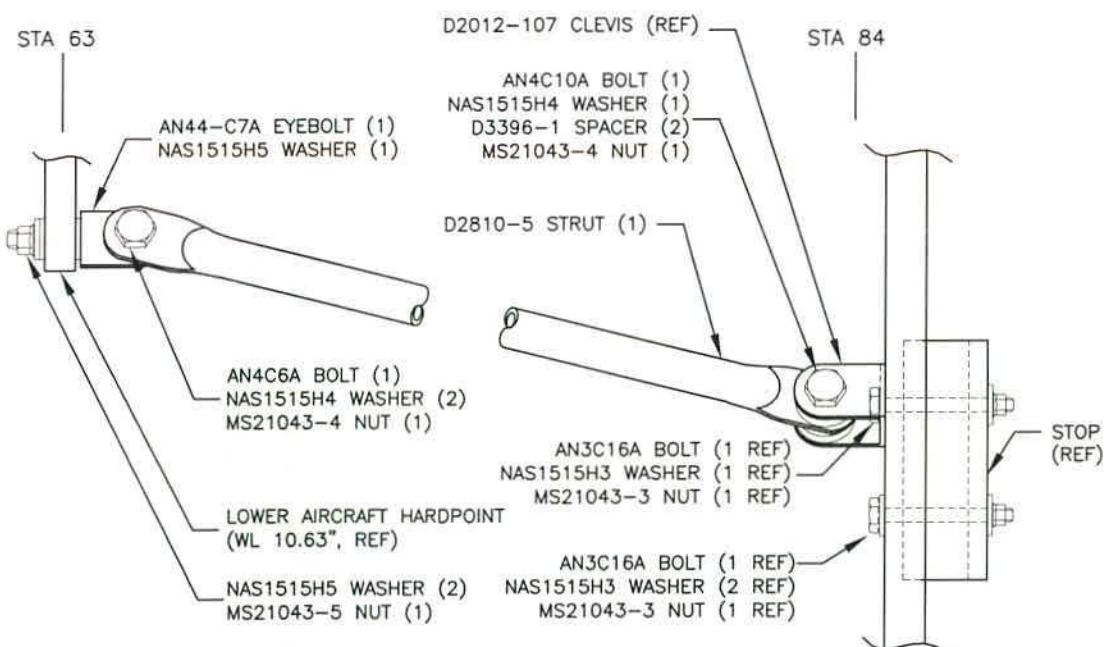
D412-630-033/-034 Heli-Access-Step™ InstallationFIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

FIGURE 16 – Strut Detail for D412-630-033/-034 *Heli-Access-Step™* Installation
(NOT TO SCALE)

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Revision: K
Date: 06.10.05

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807	GAS SPRING
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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